

Work Order ID 85026

85026

Page 1

May-31-12 1:08:25 PM

Item ID: D3319-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 31/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/12

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	C								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3319								
<u>1010 .048</u>	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

12 0 Jm
12-6-1

12 0 Jm
12-6-1

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

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Date:

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

140

Brake NC

NC BRAKE

0.00

0.00

Memo

1- Form using DT8326 & DT8261 as per Dwg D3319Rev: C
2- Form flat on press using DT8776 block

12

12/06/04

150

150

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

0.00

Memo

12/06/04

42

160

160

Large Fab

Large Fab

Weld per dwg A/R Hardcoat steel Batch: ML21603
Large Fab

0.00

Memo

1- Layout weld location as per Dwg D3319 using jig D3319-1T3
2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: C
Qty Part Number Description Batch
A/R N/A 228/7560 Hardcoat Rod ML21603

X11

41 MAL

12/07/12

Pho →

W/O: 85026 85026


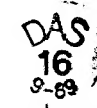


WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3319-1 PAR #: Fault Category: Large Prob. / welding NCR: Yes No DQA: OK Date: 12/07/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/7/13

NCR: 121589

WORK ORDER NON-CONFORMANCE (NCR) 5193

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/07/12	#160	Qty x1 Plate SCRAP when welder was grinded burn through it wasn't noticed that he was grinding	 057042 12/07/13	- SCRAP + Destroy Qty x1 no further	MAL 12/07/13	 12/07/13	 12/07/13 057042	 12/07/13
		if a hole torn R.L. Lock of strain in grinding parts.						

NOTE: Date & initial all entries

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85026

Page 3

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Item Name: Wearplate

Start Date: 31/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170 QC10- Inspect visual per QSI004- ground welds

0.00



12/07/13

170

QC

Memo

0.00

Quality Control

(+6)

(+1)

180 QC5- Inspect part completeness to step on W/O

0.00



12/07/13

180

QC

Memo

0.00

Quality Control

(+6)

(+6)

190 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

190

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30
320 °F
9:00

11X

MZ
12/07/16

M12/279

W/O:		WORK ORDER CHANGES					
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Revision ID:

Item Name: Wearplate

Stop

NS2

Start Date: 31/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

11x f 12-07-11

210

Identify as per dwg & Stock Location: **81916** 0.00

Packaging

210

Packaging

Memo

0.00

Packaging

11x SP 12-7-16

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/7/17 JF 12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-31-12 1:08:30 PM

Page 1

Work Order ID: 85026

85026

Parent Item: D3319-1

D3319-1

Parent Item Name: Wearplate

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B05.10.14Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	7.0960	0.628	6.610526			

M1010S18GA

1010/1025 SHEET .048

**

Location

Loc Qty

Loc Code

MAT019

7.096

116268

3

117806

4.096

117806

Jm

12-6-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 85026
Description: Wearplate		Part Number: D3319-1
Inspection Dwg: D3319	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.98	+/-0.030	4.983"	✓		✓	mmol
1.600	+/-0.010	1.602"	✓		✓	
2.660	+/-0.010	2.665"	✓		✓	
3.190	+/-0.010	3.198"	✓		✓	
3.563	+/-0.010	3.563"	✓		✓	
4.71	+/-0.030	4.710"	✓		✓	
0.60	+/-0.030	0.601"	✓		✓	
10.576	+/-0.010	10.576"	✓		MT	H13-01
11.942	+/-0.010	11.942"	✓		MT	H13-01
18.09	+/-0.030	18.09"	✓		MT	
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	0.316" x 0.546"	✓		✓	mmol
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	0.316" x 0.673"	✓		✓	
Ø0.190	+0.005/-0.001	0.192"	✓		✓	
3.815	+/-0.010	3.817"	✓		✓	
16.100	+/-0.010	16.100"	✓		MT	H13-01

Measured by: JM	Audited by: S	Preliminary Approval:
Date: 12-6-1	Date: 12/6/04	Date:

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	

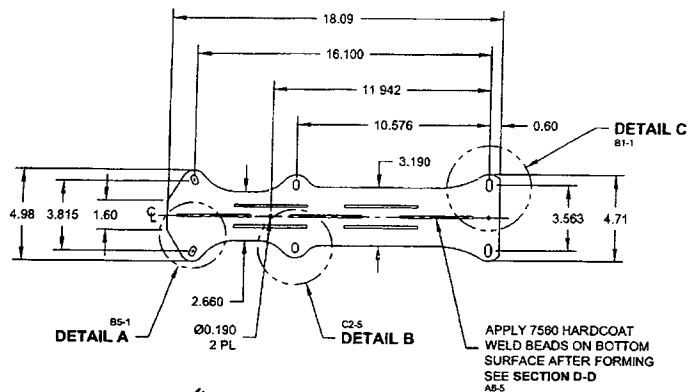
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

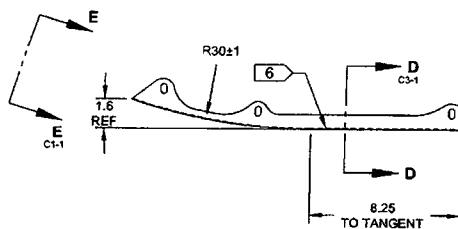
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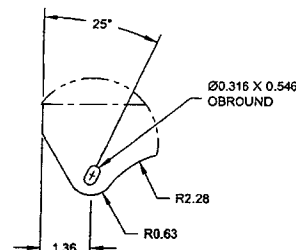
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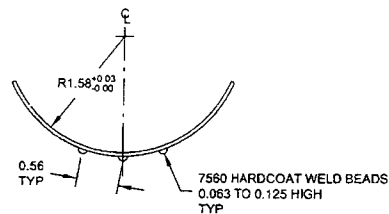
D3319-1F FLAT PATTERN



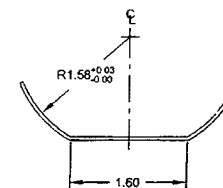
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X
C8-1



SECTION D-D
SCALE 4X
86-1



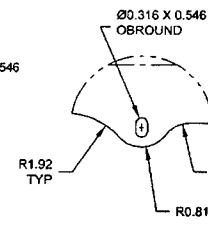
SECTION E-E
SCALE 4X
88-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

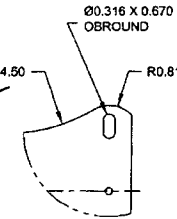
WITHOUT NOTICE
WORK ORDER

NO. 85026

12/05/31



DETAIL B
SCALE 4X
C8-1



DETAIL C
SCALE 4X
C8-1

D3319-1 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASE
2012-03-16
PER ECN 12-546 12.03.16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT. MOST HOLE ON -3/5-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/5-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. C
CHECKED	PH	D3319	SHEET 1 OF 1
MFG. APPR.	PH	TITLE	SCALE
APPROVED	PH	WEARPLATE	NTS
DE APPR.	PH	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
DATE	12.03.13	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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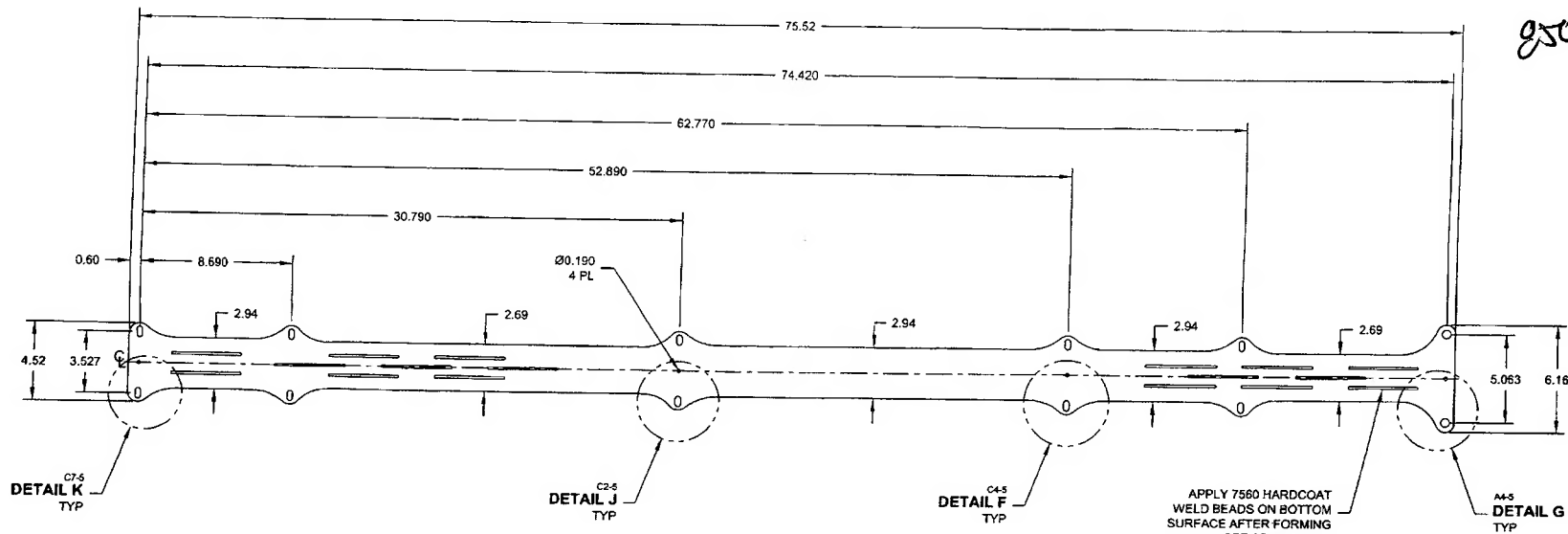
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

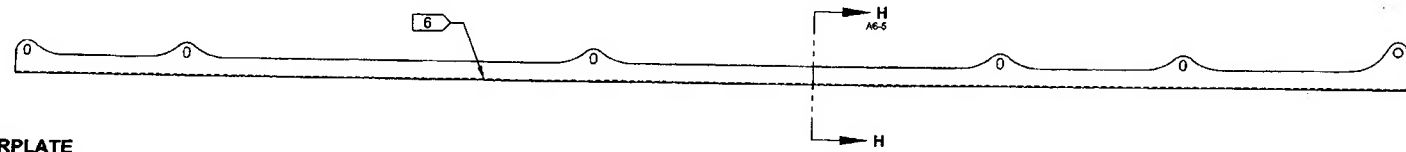
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

85026



D3319-3F FLAT PATTERN



D3319-3 WEARPLATE

D3319-3 BENDING DETAIL
MAKE FROM D3319-3F

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 3.25 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012 JUL 16
912.07.16

DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	12.03.13	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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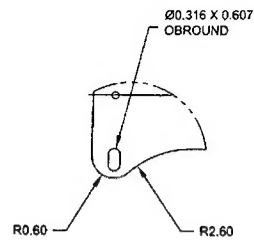
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

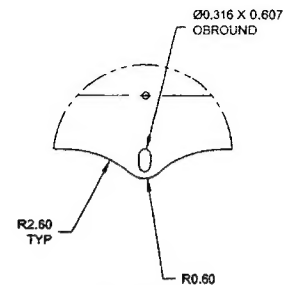
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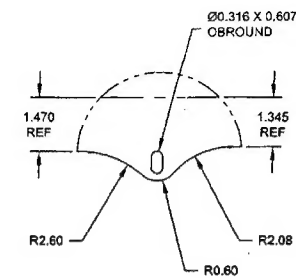
85026



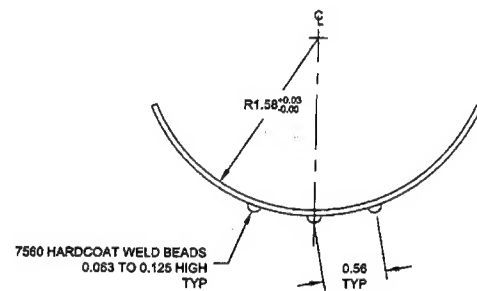
DETAIL K
SCALE 2X
B4-2
C4-3
C6-3



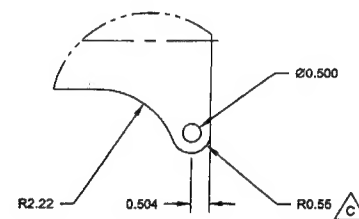
DETAIL F
SCALE 2X
B3-2



DETAIL J
SCALE 2X
B8-2
C7-3




SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B4-2
C2-3
C6-3

RELEASED
2012-02-16
412.03.16

DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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